

Abstract of the Disclosure:

A tool, in particular a shaft tool, is inserted into and fixed in a clamping chuck. The actual position of the tool, particularly in the direction of the longitudinal axis of the tool or in the direction of insertion, is determined before and/or during the insertion of the tool into the clamping chuck. Based on the determined actual position, the tool is inserted into the clamping chuck until a setpoint position has been reached.

WHS:tk-WMH-8361F//11/26/2003